

Job Set #241



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D3204-041**Job Sheet 174389****Part No:** D3204-041**Job Qty:** 4 ea**Part Name:** Release Pedal Assembly**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 3/14/18**Job Tracking No:****Due Date:** 4/7/18**Created By:** Michelle Gagnon-Donovan**Type:** SOLD**Description:****Note:** DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		4/7/18	0.00	0.00	Start Up Large Fab-1		EL
100	Large Fab	4 pcs		4/7/18	0.00	5.19	Large Fab 8		EL
110	QC	4 pcs		4/7/18	0.00	0.00	QC9		PD 18-05-15
120	QC	4 pcs		4/7/18	0.00	0.00	QC5		PD 18-05-15
130	HandFinish	4 pcs		4/7/18	0.00	0.38	HandFinish1		SA 18-05-16
140	Powdercoat	4 pcs		4/7/18	0.00	0.30	Powdercoat3		BL 18-5-22
150	QC	4 pcs		4/7/18	0.00	0.00	QC3		SP
160	Small Fab	4 pcs		4/7/18	0.00	0.27	Small Fab-3		SP
170	QC	4 pcs		4/7/18	0.00	0.00	QC5		SP
180	Packaging	4 pcs		4/7/18	0.00	0.00	Packaging3-1		SP
190	QC21-SA	4 Ea		4/7/18	0.00	0.00	QC21		SP

Part Op 100 - 1- Pierce a #30 hole center of D3204-5 to let pressure escape while welding. 2- Place parts D3204-1,3,5,13 in jig Descriptions: number DT10295 for tacking parts together.3- Remove part from jig and install spacing rods to 6" inside of D3204-3 and D3204-5; weld parts then after parts have cooled; remove spacing rods...4- Inside measurement should be @ 5.9". Then proceed to installing D3204-11 plate, then D3204-9 pedal.5- Fill #30 hole when parts are cooled to room temperature quickly at around 150 amps...

140 - ***Cover holes for bushing*** START TIME: OVEN TEMPERATURE: 300° FINISH TIME: 2:35.

180 - LOCATION : GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3204-1	Tube	4 Ea (1 ea)	90-Start up Operation	F160395
D3204-11	Plate	4 Ea (1 ea)	90-Start up Operation	F162438
D3204-13	Gusset	8 Ea (2 ea)	90-Start up Operation	S049029
D3204-3	Arm	4 Ea (1 ea)	90-Start up Operation	F162410
D3204-5	Arm	4 Ea (1 ea)	90-Start up Operation	S070446
D3204-9	Pedal	4 Ea (1 ea)	90-Start up Operation	S055732
D3204-7	Bushing	8 Ea (2 ea)	160-Small Fab	S057628

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Container No: S071184



Part: D3204-041

Job No: 174389

Serial No/Batch: S071184

Revision:

Inspector:

Date: 05/14/18

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3204-1	4	21	0
	D3204-11	4	6	0
	D3204-13	8	24	0
	D3204-3	4	6	0
	D3204-5	4	3	0
	D3204-9	4	0	0
160-Small Fab	D3204-7	8	44	0
Part Specifications				
Specifications could not be found.				

Plex 3/14/18 4:03 PM Dart.Gagnon.Michelle